

Work Order ID 129424

February-09-15 8:11:42 AM

129424

Page 1

Item ID: D5090-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bracket

Stop *NS2*

Start Date: 2/09/15 Start Qty: 12.00

12

Cust Item ID:

Required Date: 2/11/15 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D5090

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr as required

(12)

02/15/09/09

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(12)

02/15/09/09

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Page 2

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12

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Required Date: 2/11/15

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(12)

38
9-89

FEB 10 2015

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

DAS
30
9-89

12

15/02/10

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

(12)

DAS
38
9-89

FEB 11 2015

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Page 3

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12

Cust Item ID:

Required Date: 2/11/15

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

12 FF FEB 11 2015

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

(12) DAS
38
9-89
FEB 11 2015

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

(12) DAS
38
9-89
FEB 11 2015

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Page 4

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Accept

N900040100

Setup Start

NS1

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Stop

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Start Qty: 12.00

12

Cust Item ID:

Required Date: 2/11/15

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: _____

0.00

190

Packaging

Memo

0.00

Packaging

PP/28 945

~~12x~~ 15-02-11
8

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

MLJ 15-02-12

15.2.12

Picklist Print

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Page 1

Work Order ID: 129424

129424

Parent Item: D5090-1

D5090-1

Parent Item Name: Bracket

Start Date: 2/09/15

Required Date: 2/11/15

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 14.06.18 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.040

Purchased

No

sf

230.2243

14

M6061T6S 040

6061-T6 .040 Sheet

DL15/02/09

Location

Loc Qty

Loc Code

MAT021

230.2243

m130312

6.6742

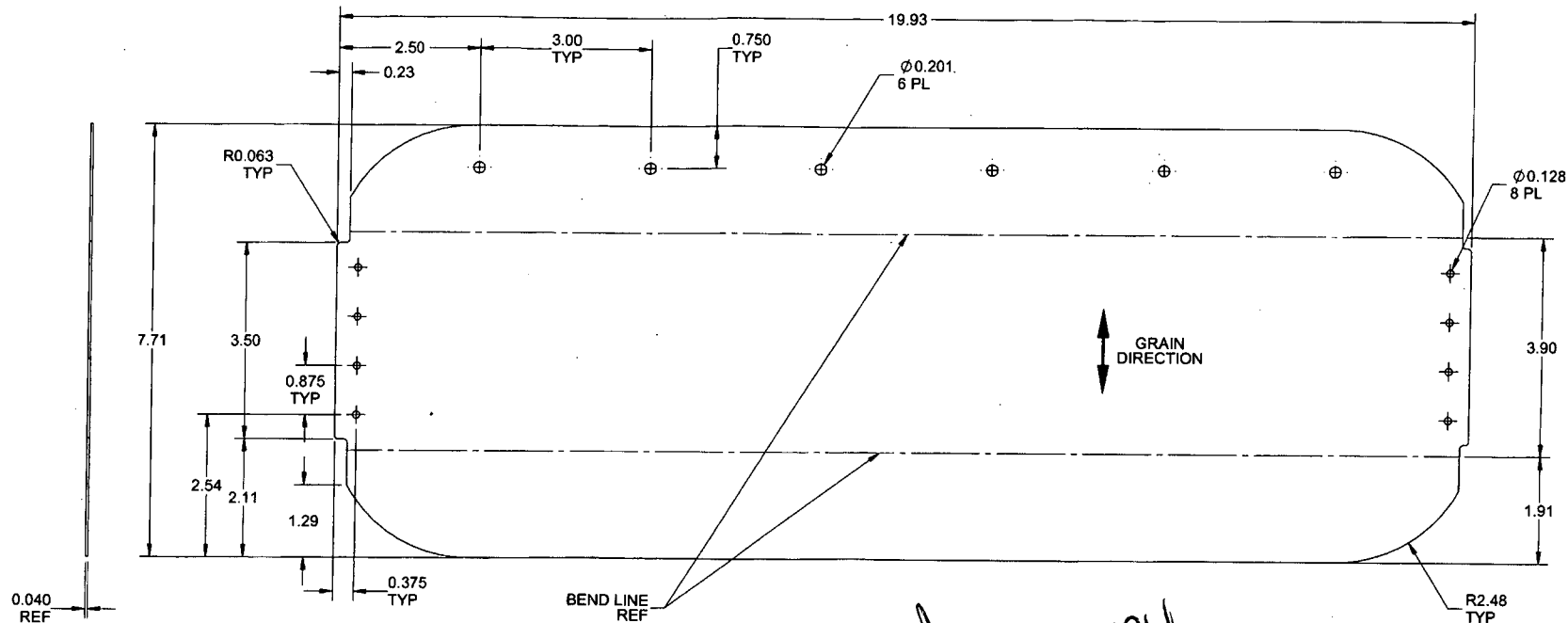
m130585

32.5501

m131352

191

16



D5090-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.58 lbs

APPROVED

DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO. D5090	REV. B
MFG. APPR.	JLM	SHEET 3 OF 5	
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	DUCT ASSEMBLY	NTS
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RELEASED
2014-07-24

8 7 6 5 4 3 2 1

D

C

B

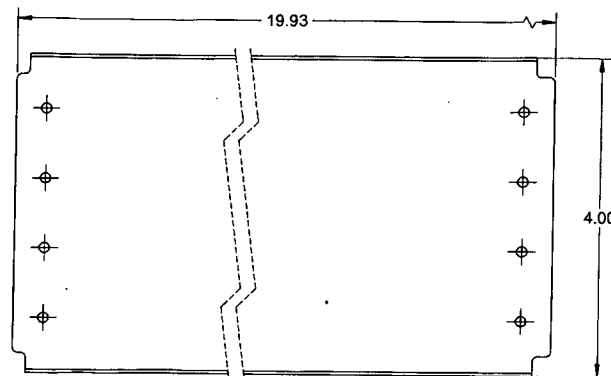
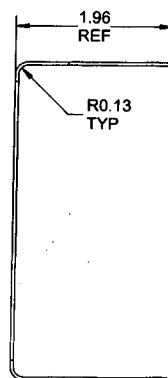
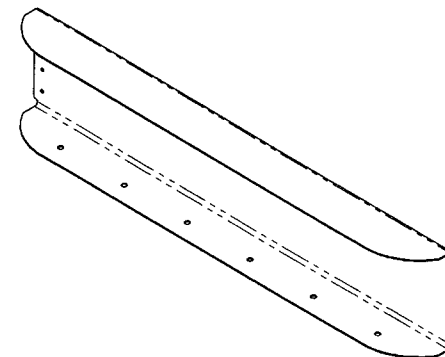
A

D

C

B

A



D5090-1 BRACKET

RELEASED
2014-07-24

- NOTES:
- 1) MATERIAL: MADE FROM D5090-1F
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
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DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
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8 7 6 5 4 3 2 1

29424

FIRST ARTICLE INSPECTION CHECKLIST

DAS

~~38~~
9-89

